

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019618**Date Inspected:** 31-Jan-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Qiu Wen.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG components.**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Mr. Shailesh Wadkar was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS)

Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA Inspector observed and/or found the following:

Bay 14:

This QA Inspector observed the following work in progress:

OBG Seg 13BW:

The Shielded Metal Arc Welding (SMAW) process on weld joint no: SEG3013P-222 [RS3431B stiffener on Side Panel (SP) 3099A to Floor Beam (FB) 3176A, complete joint penetration (CJP) weld at Panel Point (PP) 118]. The welder is identified as 066361 and was observed welding in the 3G position. ZPMC Quality Control (QC) was identified as Zhang Ling. The welding variables recorded by QC appeared to comply with welding procedure specification (WPS): B-P-2213-TC-U4b-FCM-1.

The Flux Cored Arc Welding (FCAW) process on weld joint no: SEG3013P-163 (I-rib stiffener on SP3100A to FB3176A, CJP weld at PP118). The welder is identified as 067876 and was observed welding in the 3G position. ZPMC QC was identified as Zhang Ling. The welding variables recorded by QC appeared to comply with WPS: B-T-2233-ESAB.

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This QA Inspector observed ABF personnel performing Magnetic Particle Testing (MT) on X4082S stiffener [of Deck Panel (DP) 3122A] to FB3191A weld at PP119+1500. See attached photo for further information.

OBG Seg 14W:

The SMAW process on weld joint no: DP3171-001-221 (DP3171A to RS stiffener, PJP weld). The welder is identified as 037779 and was observed welding in the 2G position. ABF QA was identified as Shao Jian Yuan. The welding variables recorded by QC appeared to comply with WPS: B-P-2212-TC-U4b-FCM-1.

Repair welding of weld joint no: SEG3020D-052 [Bottom Plate (BP) 3092A to FB3343A, CJP weld at PP128.3]. The welder is identified as 066038 and was observed welding in the 2G position. Welding process was identified as SMAW. ZPMC QC was identified as Wang Xiang Pin. The welding variables recorded by this QC appeared to comply with WPS: 345-SMAW-2G(2F)-FCM-Repair. Repair welding was done as per Critical Welding Repair (CWR) Report: B-CWR 2734 Rev-1.

Repair welding of weld joint no: SEG3020Y-022 [FB3327A to Longitudinal Diaphragm (LD) 3051A, CJP weld at PP127]. The welder is identified as 045246 and was observed welding in the 3G position. Welding process was identified as SMAW. ZPMC QC was identified as Wang Xiang Pin. The welding variables recorded by this QC appeared to comply with WPS: 345-SMAW-3G(3F)-FCM-Repair. Repair welding was done as per CWR Report: B-CWR 2792 Rev-0.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No significant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang; phone: 15000422372., who represents the Office of Structural Materials for your project.

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Inspected By:	Wadkar,Sailesh	Quality Assurance Inspector
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Reviewed By:	Peterson,Art	QA Reviewer
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